

Date: Monday, 11/08/2008 1:02:30 PM
 User: Melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 412 SKI WEARPLATE
Job Number	: 41110		
Estimate Number	: 13543		
P.O. Number	:	Part Number	: D3796043
This Issue	: 11/08/2008 S.O. No. :	Drawing Number	: D3796 REV.A PREL
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : R & D SM/MED FAB	Drawing Revision	: PRELIM
Previous Run	: 41010	Material	:
Written By	:	Due Date	: 18/08/2008 Qty: 3 Um: Each
Checked & Approved By	: <u>MF 08-08-11</u>		
Comment	: Est Rev:A 08-08-05 new issue DD verified by:ec		

Additional Product

PRELIMINARY ISSUE

Job Number:

POSITIVE
RECALL

Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 Sheet.063
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Comment: Qty.: 2.0076 sf(s)/Unit Total: 6.0228 sf(s)

NEOPRENE SHEET 0.063

batch: 108724 B 8-8-11

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3796

Dwg Rev: PRE B 8-8-11Prog Rev: PRE2-Deburr if necessary B 8-8-11

③

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

B 8-8-11

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

S 08/08/12 (43)

5.0	D30093	Cup
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Comment: Qty.: 12.0000 Each(s)/Unit Total: 36.0000 Each(s)

Cup

batch: B41075

Date: Monday, 11/08/2008 1:02:30 PM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 SKI WEARPLATE

Job Number: 41110

Part Number: D3796043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

SS Rod B# M107057
2059B B# M108631



Weld hardcoat (template DT9037) and cups as per dwg D3796

EL 8-8-14

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Cpl 08-08-14



(2X)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ENGINEERING
APPROVAL



08-08-14 (2)

08-08-20

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1



(2X)

Identify and Stock
Location: ~~41077~~ 41077

8/8/14

SU

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE



08/09/09

Job Completion



POSITIVE RECALL

EFFECTIVE 08-08-11

AUTH W

RELEASED

DATE 08-08-14

Start: 1-30

Temp: 320

Finish: 2-00

(X2)

M.H. 04/25/14

080208

8.1 Powdercoat grey as per dwg.

8.2 QC 3. HJ 08-08-14

DART AEROSPACE LTD		Work Order:	41110
Description: 412 SK. WEAR PLATE		Part Number:	D 3796-3
Inspection Dwg: D3796-3 Rev: PRE		Page 1 of 1	

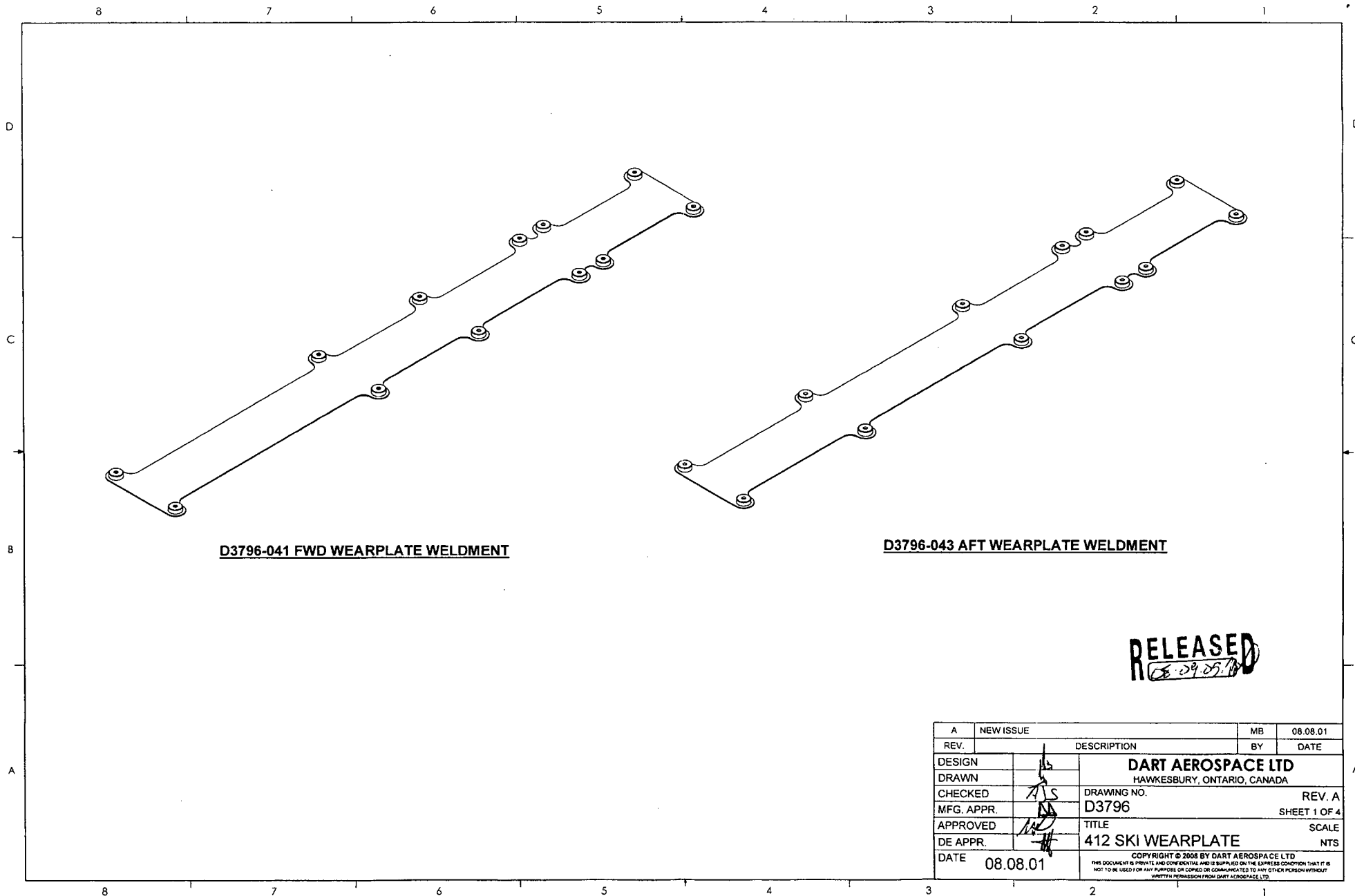
FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article** ☐ **Prototype**

[illegible]

Measured by: <i>RB</i>	Audited by: <i>S</i>	Prototype Approval: <i>1</i>
Date: <i>8-8-11</i>	Date: <i>08/08/12</i>	Date: <i>1/7</i>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

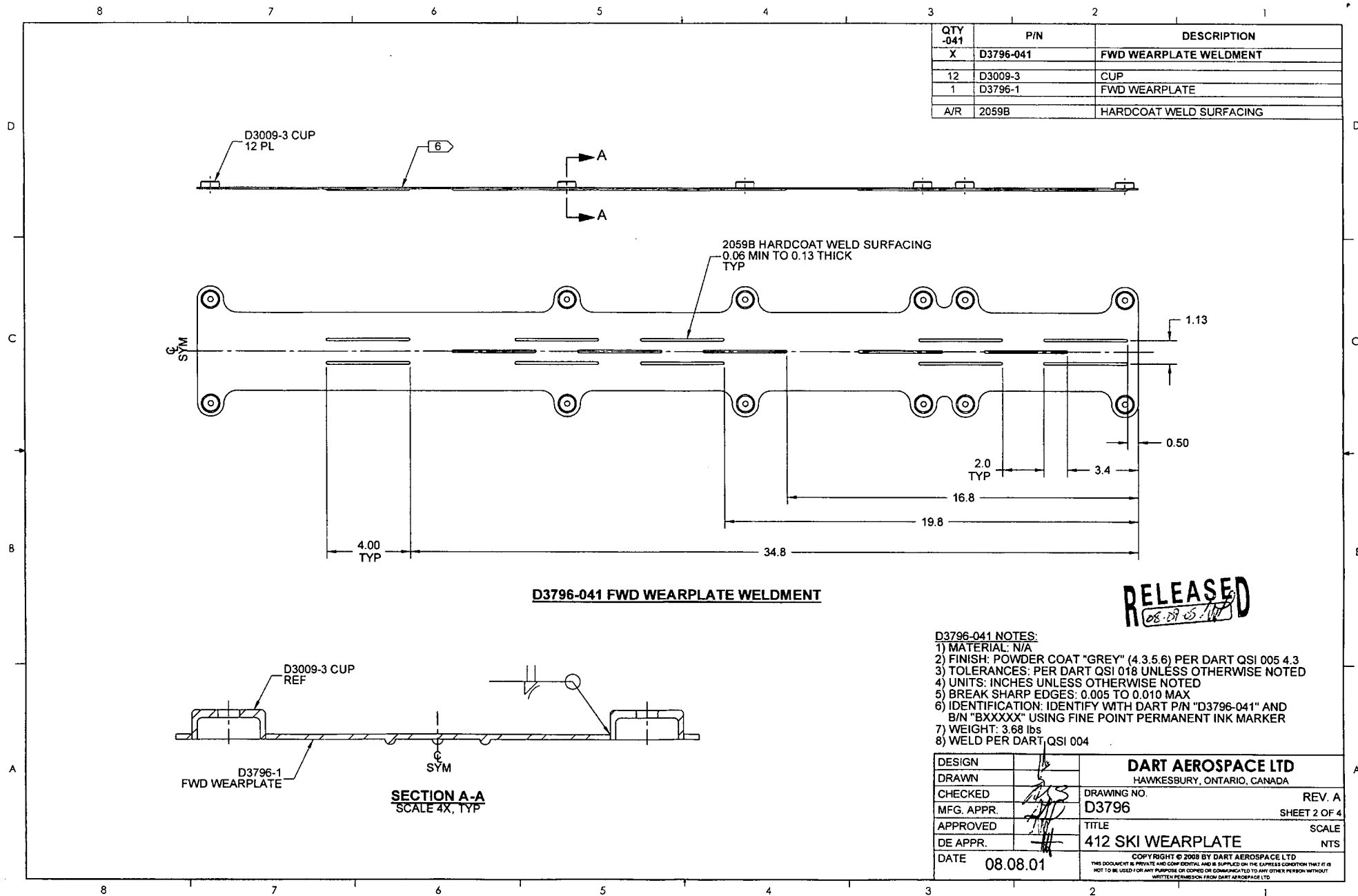


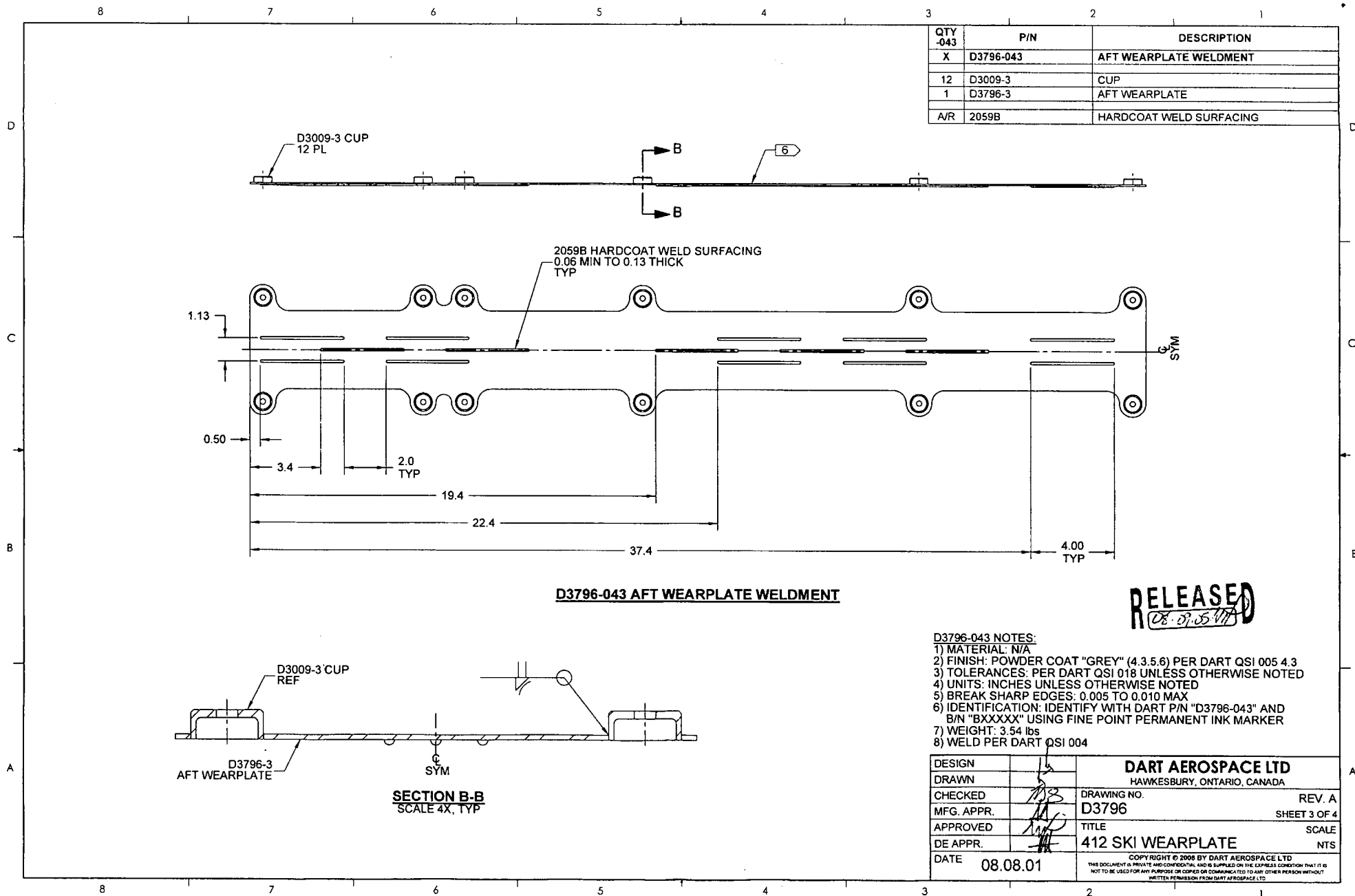
D3796-041 FWD WEARPLATE WELDMENT

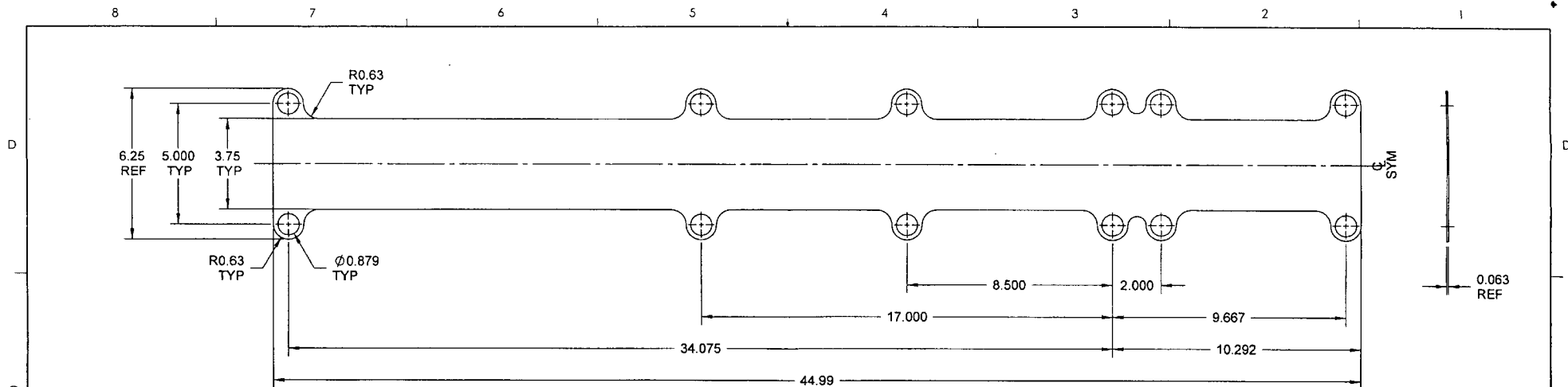
D3796-043 AFT WEARPLATE WELDMENT

RELEASED
08-09-05

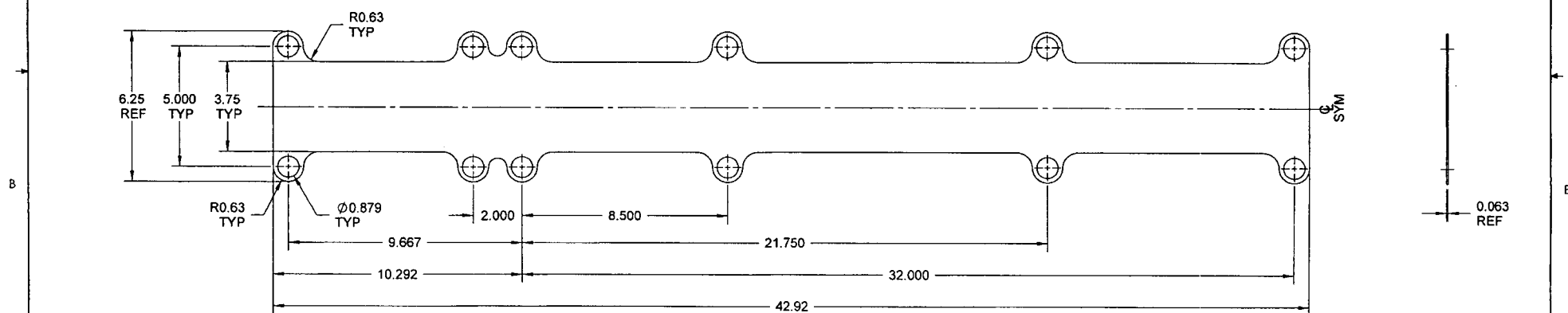
A	NEW ISSUE	MB	08.08.01
REV.	DESCRIPTION	BY	DATE
DESIGN	16	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AS		
CHECKED	AS	DRAWING NO.	REV. A
MFG. APPR.	AS	D3796	SHEET 1 OF 4
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	412 SKI WEARPLATE	NTS
DATE	08.08.01	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	







D3796-1 FWD WEARPLATE



D3796-3 AFT WEARPLATE

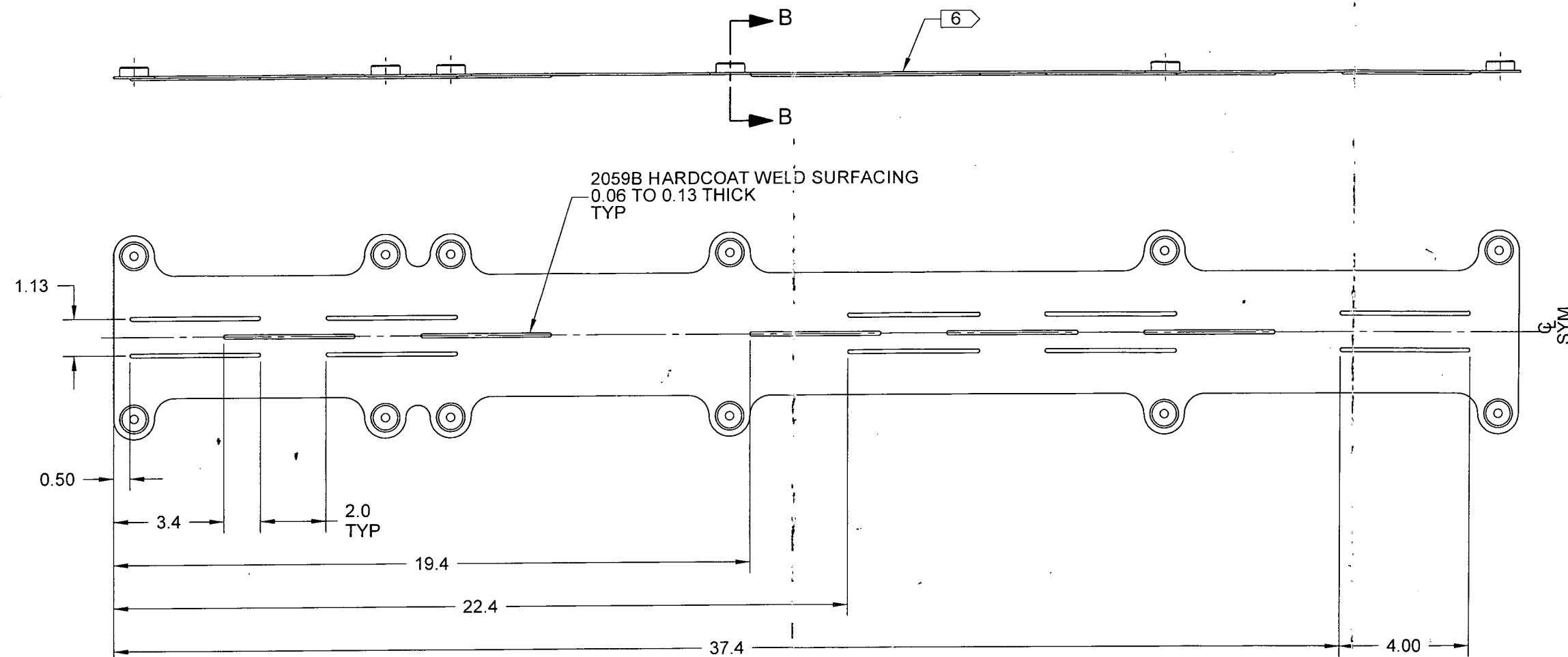
D3796-1/-3 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT:
D3796-1 = 3.25 lbs
D3796-3 = 3.11 lbs

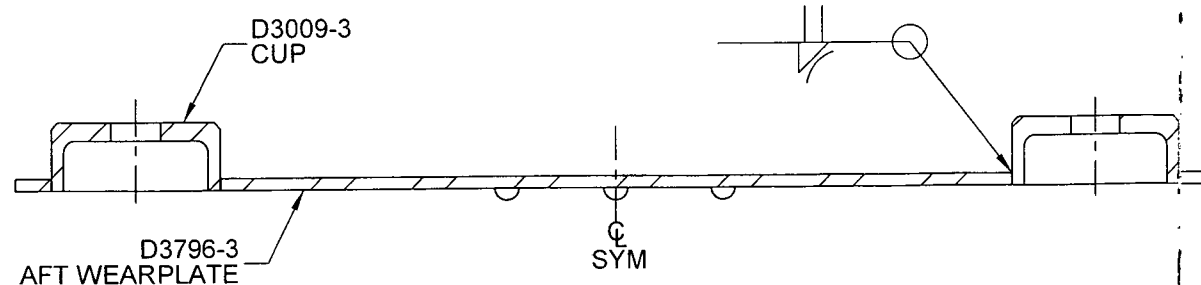
RELEASED
08-09-03/14

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3796	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		412 SKI WEARPLATE	NTS
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QTY -043	P/N	DESCRIPTION
X	D3796-043	AFT WEARPLATE WELDMENT
12	D3009-3	CUP
1	D3796-3	AFT WEARPLATE



D3796-043 AFT WEARPLATE WELDMENT



SECTION B-B
SCALE 4X

PRELIMINARY ISSUE
108.08.05
Rev ECW #08-501P

D3796-043 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3796-043" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 3.54 lbs
- 8) WELD PER DART QSI 004

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3796	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		412 SKI WEARPLATE	NTS
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AT 9037